

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-137** Date Opened: **09 August 2017**Title: **Assembly**Aircraft OEM: **Airbus Helicopters**Aircraft Model: **AS350**Product Type: **Bike Rack**Product Model: **Base**Quantity: **2 LH / 2 RH****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100215	0	Bike Rack Base Ass'y	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2 / 2
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
JC
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: D. Martyn

Sign:

SCA: AD05

Date: 21-Aug-17

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign:

SCA: AD02

Date: 21-Aug-17

Work Order closed by:

Print: J. Clarke

Sign:

SCA: AD02

Date: 12-Sep-17

Approved Manufacturing Facility 73-04

Form 20.003

Rev. Original 23 Sep 2014

Aero Design Ltd.
Component Fabrication

Work Order Number: 2017-137

100215-01 Bicycle Rack Base

Date: 09 AUG 2017

Notes:

Drilling speed to 320 RPM.

Rapid Tap cutting fluid or equivalent coolant required

Rail

Tasks

SCA

1.	Record material PO below	See PDS
2.	Cut 78230 step extrusion to 82.75" in length	PCW
	On each end, cut the side and bottom walls shorter by 1/8" leaving the tread rail full length IAW drawing 100215 Detail B	PCW
3.	Deburr one end on buffing wheel	PCW
4.	On the bottom wall, place a mark 7/8" from each end and drill 3/8" hole which will act as a drain and allow ventilation during the welding process	PCW

Manual Mill

5.	While supporting the long end of the rail, clamp aft end (dependant on LH or RH) into the manual mill vice	PCW
6.	Using standard practices, zero off of the end and back of the part and set zero on the X and Y axis on the digital display	PCW
7.	Set table to drill locations IAW drawing 100215 Detail C and bore .75" holes	PCW
8.	Deburr edges and holes	PCW

Welding

9.	Wipe parts with Acetone or equivalent solvent	PCW
10.	Place 100226-01 bushings in .75" holes and locate them IAW drawing 100215 Detail C	PCW
11.	Weld IAW drawing 100215	PCW
12.	Place cap 82720-04 on each end and weld IAW drawing 100215 Detail B	PCW

Beam

13.	Cut 1" x 8" 6061-T6 extruded bar to 24 7/8" in length.	PCW
14.	Install material in CNC mill ensuring RH edge overhangs for tool clearance	PCW
15.	Set material stop to ensure subsequent steps and parts return to the same location	PCW
16.	Load and run program 021 and 022	PCW
17.	Rotate part 180 degrees on plane	PCW
18.	Load and run program 021 and 022	PCW
19.	Separate parts by cutting along mark scribed during machining process	PCW

20.	Install 100230 jig plate into CNC straddling vices and lock down	PCW
21.	Using a soft face hammer, tap the jig down to ensure it is seated	PCW
22.	Zero table using standard practices	PCW
23.	Mount separated part on jig using 1/4" bolts	PCW
24.	Load and run program 023	PCW
25.	Using vertical band saw, remove tooling lug at the outboard end	PCW
26.	On manual mill, zero off the end of the part using standard machining practices	PCW
27.	Using standard practices, machine surface area from which lug was removed	PCW
28.	Inspect finish and dimensions of final part.	PCW

Rack Base Assembly

29.	Insert Helicoils in threaded bushings IAW drawing 100226	PCW
30.	Install bike rack base beams into jig fixture	AD-05
31.	Install rails into beams	AD-05
32.	Weld IAW drawing 100215	AD-05
33.	Inspect finish and dimensions of final part.	AD02
34.	Tag completed parts IAW Aero Design MPM.	AD-05

Material Purchase Order Number See PDS
 Batch Quantity 2 LH / 2 RH



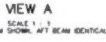
WO# 2017-137




Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



4. INSTALL PLACARD AFTER SURFACE FINISH IS DRY.



BASIC CODE DES. NO. WAS 553 C-CLASSIFICATION DES. NO. FOR LENGTH DES. NO. OF SHEETS TO BE SHIPPED		DASH NO. FOR DIMENSIONS DASH NO. FOR NEW DES. OR MODIFICATION DES. NO. FOR SPECIFICATIONS UNLESS OTHERWISE SPECIFIED TOLERANCES IN DECIMALS ANGLES ANGLES S.D. 0.010 1/12° R.S. 0.003 X.X 0.03 EXISTING INCH		APPROVALS JEFF CLARK 13 JUNE 2006 JUDITH REYNOLDS 13 JUNE 2006 DATE 13 JUNE 2006		 AERO DESIGN LTD. MISSA MANUFACTURING POWELL REYNOLDS, INC. CANADA, VAN. BC CANADA	
BASIC CODE DES. NO. WAS 102470 C-CLASSIFICATION DES. NO. FOR LENGTH DES. NO. OF SHEETS TO BE SHIPPED		DASH NO. FOR DIMENSIONS DASH NO. FOR NEW DES. OR MODIFICATION DES. NO. FOR SPECIFICATIONS UNLESS OTHERWISE SPECIFIED TOLERANCES IN DECIMALS ANGLES ANGLES S.D. 0.010 1/12° R.S. 0.003 X.X 0.03 EXISTING INCH		APPROVALS JEFF CLARK 13 JUNE 2006 JUDITH REYNOLDS 13 JUNE 2006 DATE 13 JUNE 2006		 AERO DESIGN LTD. MISSA MANUFACTURING POWELL REYNOLDS, INC. CANADA, VAN. BC CANADA	
BASIC CODE DES. NO. WAS 102470 C-CLASSIFICATION DES. NO. FOR LENGTH DES. NO. OF SHEETS TO BE SHIPPED		DASH NO. FOR DIMENSIONS DASH NO. FOR NEW DES. OR MODIFICATION DES. NO. FOR SPECIFICATIONS UNLESS OTHERWISE SPECIFIED TOLERANCES IN DECIMALS ANGLES ANGLES S.D. 0.010 1/12° R.S. 0.003 X.X 0.03 EXISTING INCH		APPROVALS JEFF CLARK 13 JUNE 2006 JUDITH REYNOLDS 13 JUNE 2006 DATE 13 JUNE 2006		 AERO DESIGN LTD. MISSA MANUFACTURING POWELL REYNOLDS, INC. CANADA, VAN. BC CANADA	